

Work Order ID 72282

Thursday, July 21, 2011 9:02:59 AM



Page 1

Item ID:	D2989-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Basket Lid Assembly					
Start Date:	7/21/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	8/2/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:		Date:	11-07-21	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2989	Rev D								

100		0.00							
	Large Fab								
Large Fab									
Large Fab									

Memo

1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989

2- tack weld mesh on basket as per dwg D2989 using DT9445 jig
****cut cutouts with zip cut as per dwg D3832****

3- remove from jig and weld lable plate as per dwg D2989
A/R ER316 S.S. Rod Batch: 1114649

*** PLEASE NOTE***

IF MAKING -043A :

ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER
DSI9473

110		0.00							
	QC								
QC									
Quality Control									

Memo

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

11-07-28
BE 11/07/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72282

Thursday, July 21, 2011 9:03:00 AM

Page 2

Item ID: D2989-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Basket Lid Assembly

Start Date: 7/21/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

11 07 28 (1)

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 6 11/07/28

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D2989-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Basket Lid Assembly
Start Date: 7/21/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 8/2/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M117745</i>	0.00				<u>1</u>		<i>11-7-28.</i>	
Powdercoat	Memo	0.00							

Powder Coating


1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:
START TIME: 8:00
OVEN TEMPERATURE: 400°
FINISH TIME: 3:50.
***** 2nd coat if necessary*****

2ND COAT:
START TIME: _____
OVEN TEMPERATURE: _____
FINISH TIME: _____

1 0 11 107/29

131 	Wing Walk as per dwg QSI005 4.4 Batch <i>M11786</i>	0.00							
HandFinish	Memo	0.00							

Hand Finishing

Mask lid prior to spray paint black and wing walk as per dwg
A/R Spray paint black batch: *M117162*

W/O:		WORK ORDER CHANGES					
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Page 4

Item ID: D2989-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Lid Assembly

Start Date: 7/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EB 11/08/09 @

141

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

Packaging

w/o
72280

EB 11/08/09 @

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/08/10

11-08-9 @

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Thursday, July 21, 2011 9:03:06 AM



1. The first step is to identify the problem or question that needs to be addressed. This involves understanding the context and the specific requirements of the task.

2. The second step is to gather relevant information and resources. This may involve researching existing solutions, consulting with experts, or collecting data.

3. The third step is to develop a plan or strategy. This involves breaking down the problem into smaller, manageable tasks and determining the sequence of steps to be taken.

4. The fourth step is to implement the plan. This involves carrying out the tasks identified in the plan, often in a systematic and organized manner.

5. The fifth step is to evaluate the results. This involves comparing the outcomes of the implementation against the original goals and objectives to determine the effectiveness of the solution.

6. The sixth step is to reflect on the process. This involves considering what worked well, what challenges were encountered, and what lessons can be learned for future tasks.

7. The seventh step is to communicate the findings. This involves sharing the results of the process with relevant stakeholders, providing a clear and concise summary of the findings.

8. The eighth step is to document the process. This involves creating a record of the steps taken, the resources used, and the results achieved, which can be used for future reference.




9. The ninth step is to seek feedback. This involves asking for input from others who have been involved in the process or who are familiar with the problem, to gain different perspectives.

10. The tenth step is to iterate. This involves using the feedback received to refine the solution or the process, making improvements where necessary.

Required Date: 8/2/2011

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
 IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
 IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
 IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
 10.09.14 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	12.0000	2	2		11.07.25	
				<u>Location</u>									
				WA				9					
					71372			9					
				WA006				3					
					67463			3					
D2506  Label Plate		Manufactured	No			100	Each	9.0000	1	1		11.08.25	
				<u>Location</u>									
				WA				9					
					69262			1					
					71087			8					
D2512-7  Rib		Manufactured	No			100	Each	6.0000	1	1		11.07.25	
				<u>Location</u>									
				WA				4					
					53444			0					
					71220			4					
				WA006				2					
					67445			2					

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, July 21, 2011 9:03:06 AM

Page 2

Work Order ID: 72282

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/21/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100 Each

67.0000 2 2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

67

69258

28

69739

2

69766

37

D2989-13

Manufactured No

100 Each

4.0000 2 2



Rib

Location

Loc Qty

Loc Code

WA

4

71556

4

D2989-19

Manufactured No

100 Each

4.0000 2 2



Rib

Location

Loc Qty

Loc Code

WA

4

71477

4

D3832-3

Manufactured No

100 Each

1.0000 1 1



Mesh (Lid)

Location

Loc Qty

Loc Code

WA

1

69276

1

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 72282

Parent Item: D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 7/21/2011

Required Date: 8/2/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-3

Manufactured No

100 Each

19.0000

2

2



Mesh (Lid End)

B 67460



2

P.A.B 11/07/25

Location

Loc Qty

Loc Code

WA

19

67460

19

D3836-041

Manufactured No

100 Each

0.0000

1

1



Rib Assembly (Basket Lid, LH)

B71746

①



1

11.07.25

D3836-042

Manufactured No

100 Each

0.0000

1

1



Rib Assembly (Basket Lid, RH)

B71745

①



1

11.07.25

D3852-041

Manufactured No

100 Each

4.0000

1

1



Rib Assembly

Location

Loc Qty

Loc Code

WA

4

70722

4

D3852-042

Manufactured No

100 Each

5.0000

1

1



Rib Assembly



1

11.07.25

Location

Loc Qty

Loc Code

WA

5

66089

1

70723

4

Thursday, July 21, 2011 9:03:07 AM

Shop Packet Print

Page 3

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D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

RELEASED
08/11/81

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 12282
PL 11-07-21

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3836 DWG) AND D2989-11/-12 (NOW ON D3852 DWG) REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.050 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.05.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

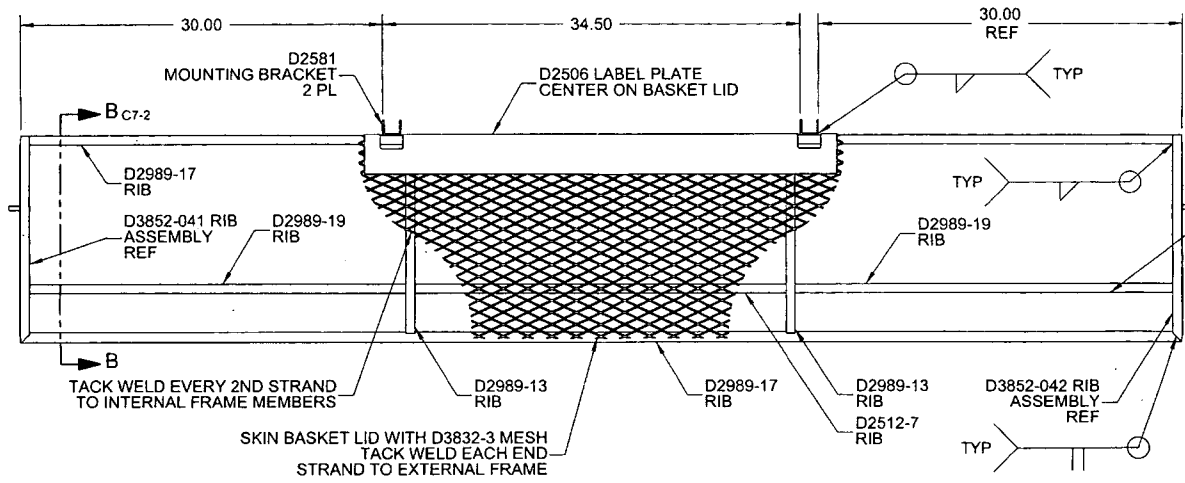
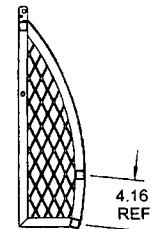
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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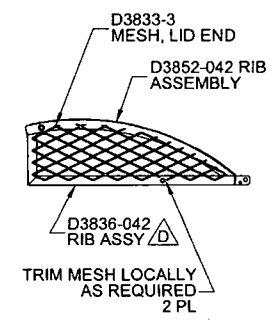
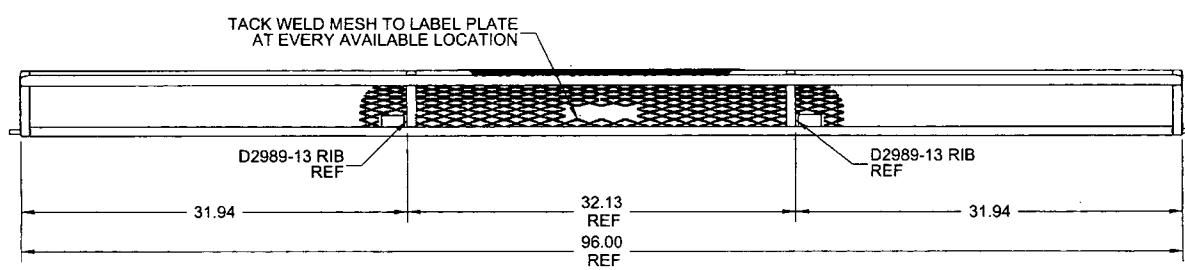
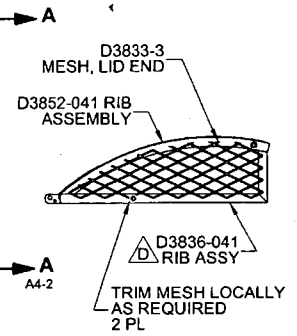
72282

SECTION B-B

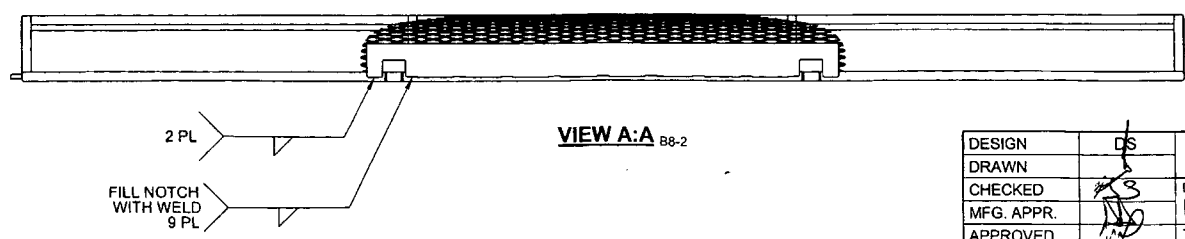


TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION IN AREA TO BE ANTI-SKID'D

BLACK ANTI-SKID PAINT THIS SECTION



D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)



VIEW A:A B8-2

RELEASED
08/11/18/19

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE BASKET LID ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

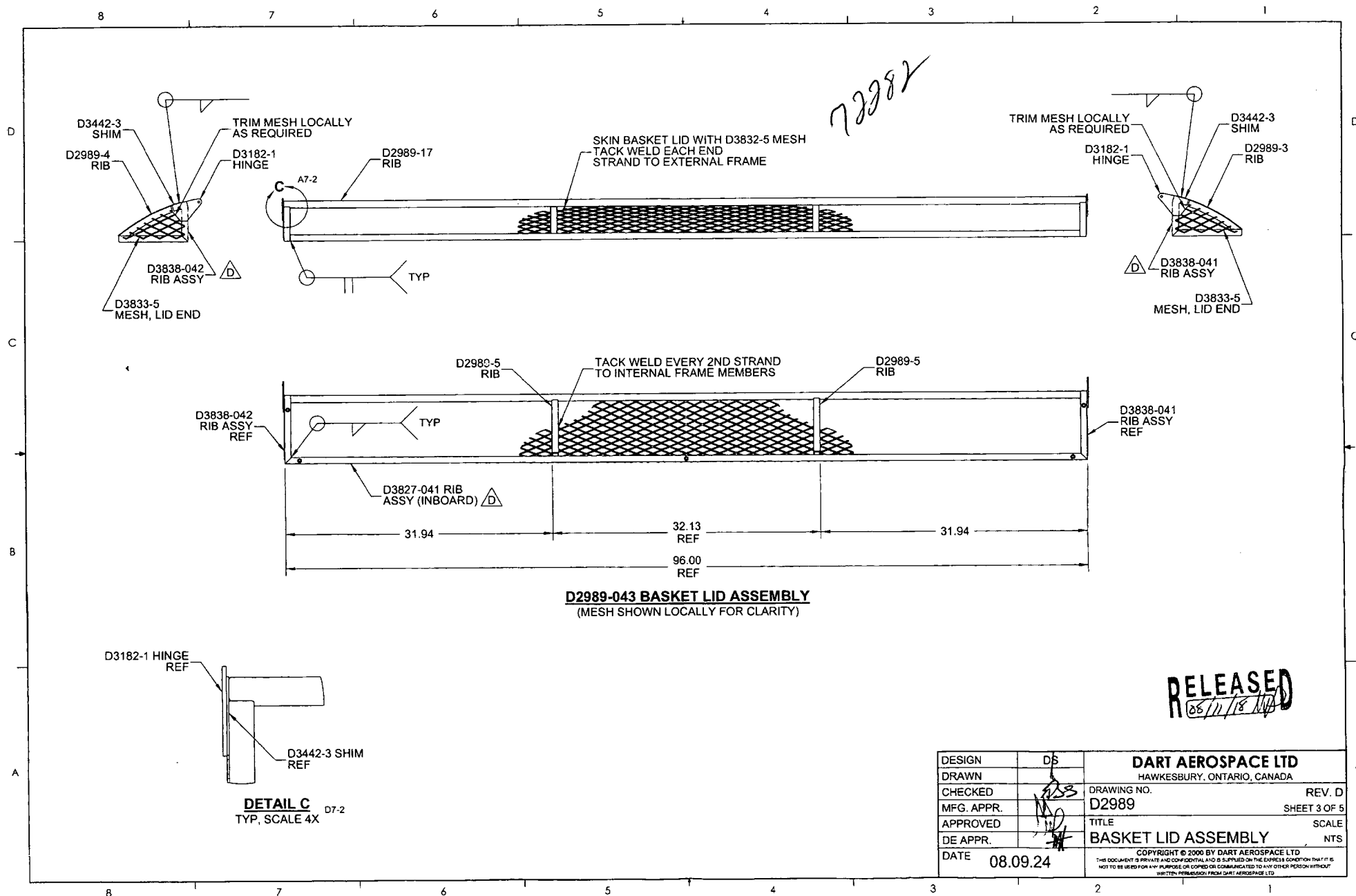
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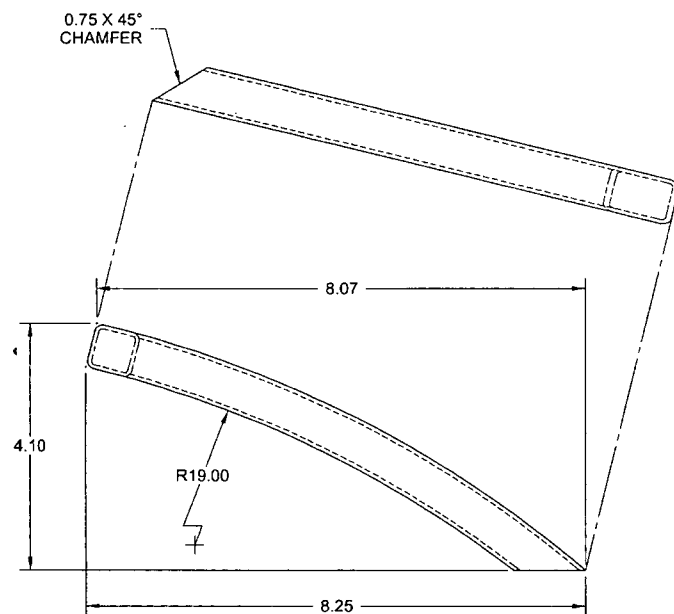
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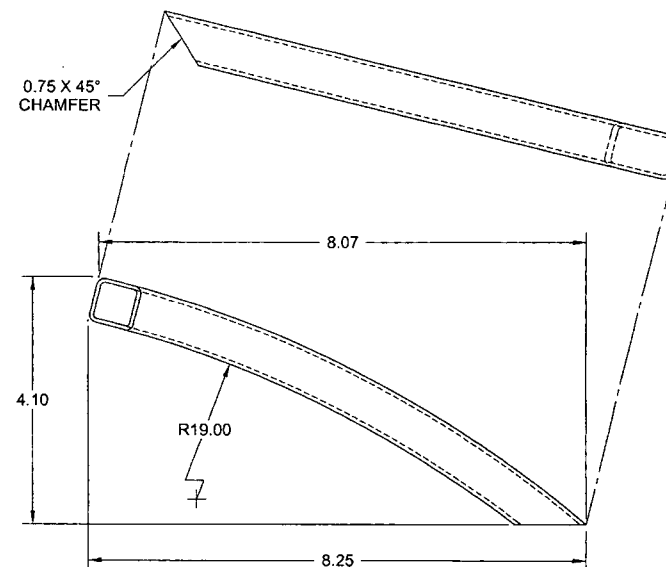
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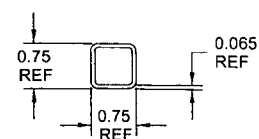
NOTE: Date & initial all entries



D2989-3 RIB



D2989-4 RIB



**TYPICAL SECTION
VIEW**

- NOTES:**
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

RELEASED
02/11/18/14

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

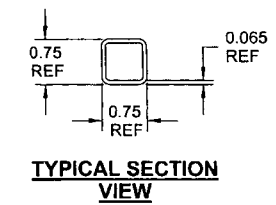
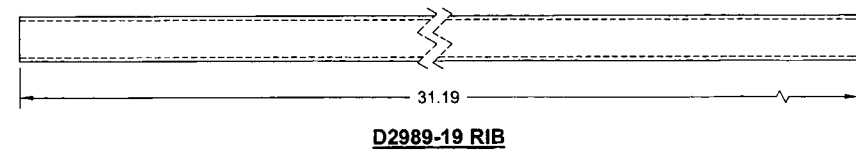
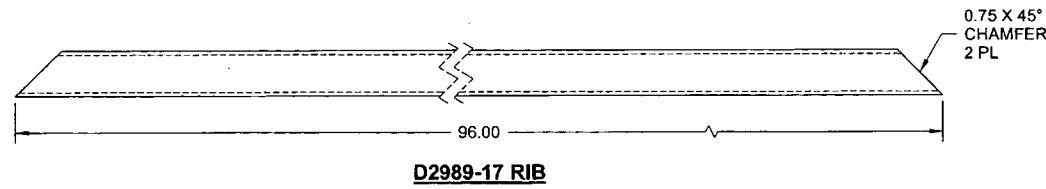
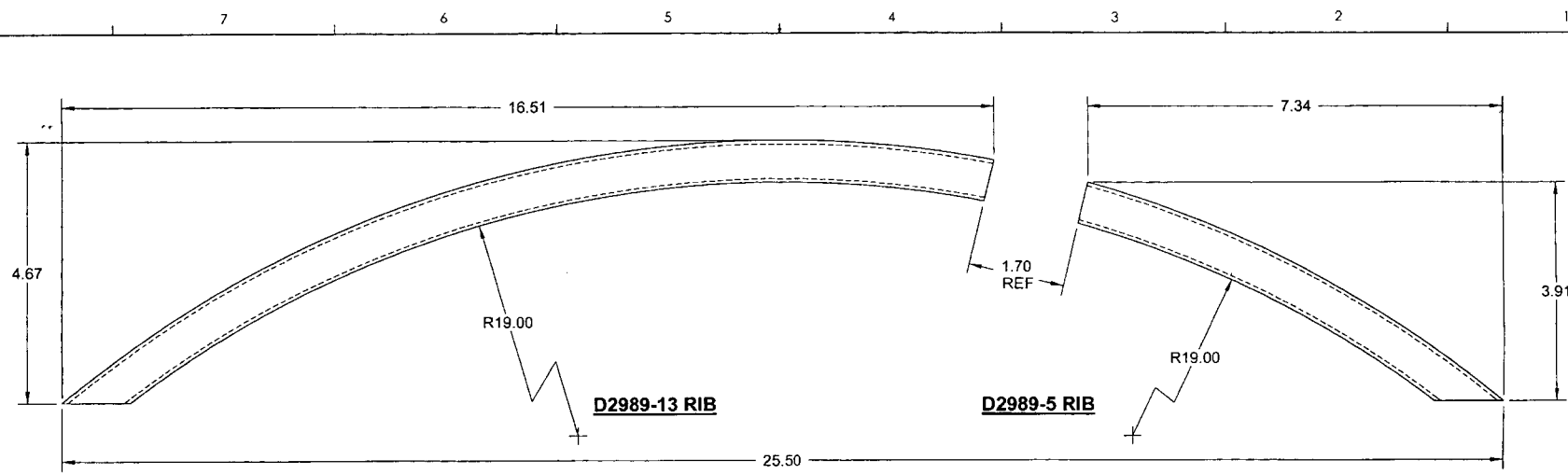
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



72282

RELEASED
08/11/18

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries